

131349

April-02-15 1:42:18 PM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 03/04/2015 **Start Qty:** 1500

Cust Item ID:

Required Date: 13/04/2015 **Req'd Qty:** 500

Customer:

Reference:

Approvals: Process Plan: _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
650.6300	

100

0.01

100

DOOSAN LATHE

Doosan

Memo

0.08

Doosan Lathe

1-Turn as per Folio FB377

Dwg Rev: *JS*

FOLIO REV: N/A

2-Deburr

DAS

40

9-89

15/04/06

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

Memo

0.00

QC

Quality Control

DAS

40

9-89

15/04/06

Work Order ID 131349

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Item ID: 650.6316 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Swivel Fitting
 Start Date: 03/04/2015 Start Qty: 5.00 *5* Cust Item ID:
 Required Date: 13/04/2015 Req'd Qty: 5.00 *5* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00				10	6		DAS 37 9-89 15.04.06
120									
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: <u>Sold</u>	0.00				(10x)			DAS 46 9-89 APR 06 2015
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							15/4/6 JJ
140									
QC	Memo	0.00							
Quality Control									

(H) 15.4-6

Picklist Print

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Work Order ID: 131349

131349

Parent Item: 650.6316

650 6316

Parent Item Name: Swivel Fitting

Start Date: 03/04/2015

Required Date: 13/04/2015

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A NEW ISSUE 15.03.19 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174PH-H900R1.000		Purchased	No				f	76.8330		1			DAS
M174PH-H900R1 000									**			15/04/06	40 9-89
17-4SS H900 ROUND BAR 1.00													

Location

Loc Qty

Loc Code

MAT031

76.833

m124334

24

m126952

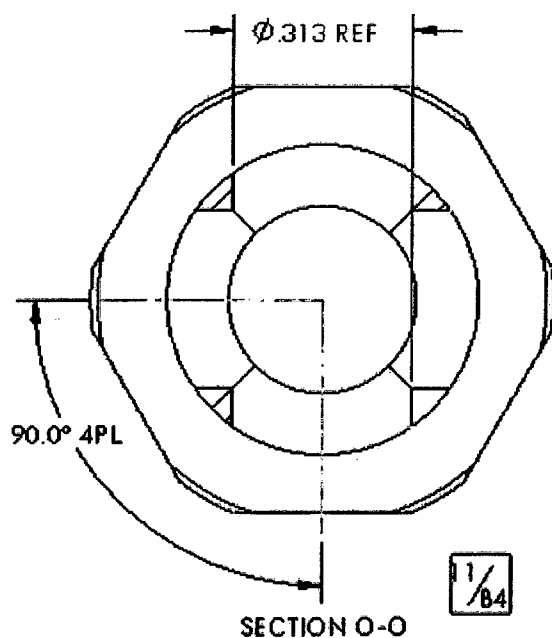
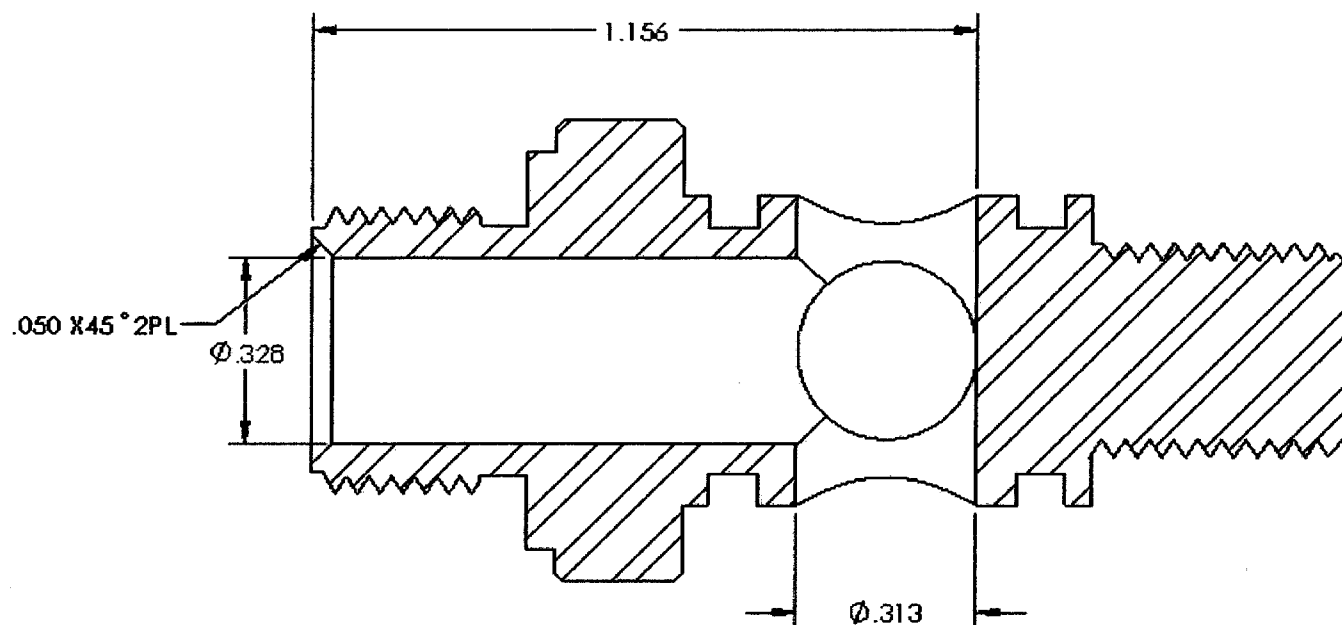
9

→ m128314

43.833

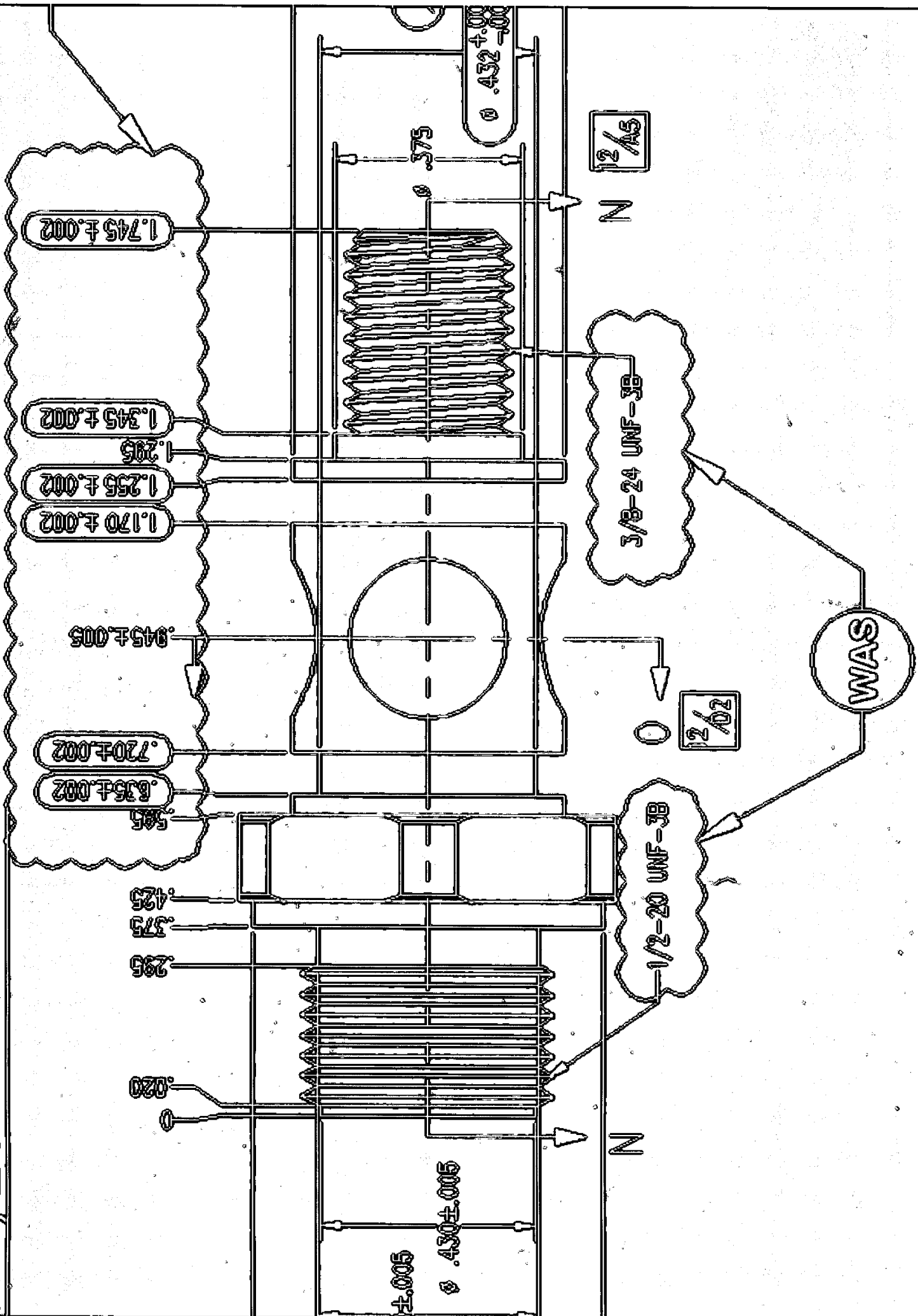
2.5

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 AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM DART INDUSTRIES, INC.



DESIGN BY 12-0-00-10 DRAWN BY N. CAP CHECKED BY S. BARN APPROVED BY S. BARN	<table border="1"> <tr> <td data-bbox="1872 1357 2000 1429"> DART INDUSTRIES, INC. 4000 W. 10th St. Tulsa, OK 74107 </td><td data-bbox="2000 1357 2083 1429"> 3030 1419 3030 1419 3030 1419 </td></tr> <tr> <td data-bbox="1872 1429 2000 1541"> SWIVEL FITTING 650.6300 </td><td data-bbox="2000 1429 2083 1541"> 3030 1419 3030 1419 3030 1419 </td></tr> </table>	DART INDUSTRIES, INC. 4000 W. 10th St. Tulsa, OK 74107	3030 1419 3030 1419 3030 1419	SWIVEL FITTING 650.6300	3030 1419 3030 1419 3030 1419
DART INDUSTRIES, INC. 4000 W. 10th St. Tulsa, OK 74107	3030 1419 3030 1419 3030 1419				
SWIVEL FITTING 650.6300	3030 1419 3030 1419 3030 1419				

T-11, ZONE A5 WAS:



DART AEROSPACE LTD	Work Order: 131 349
Description: SWINOL Fitting	Part Number: 650-6316
Inspection Dwg: 650.6300 Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .430	± .005	.429	✓		VERN	PHD-12
Ø .440	± .005	.439	✓		"	"
Ø .700	± .005	.697	✓		"	"
.295	± .005	.295	✓		"	"
.375	± .005	.374	✓		"	"
.425	± .005	Ø .424	✓		"	"
.645	± .005	.646	✓		"	"
.690	± .002	.690	✓		"	"
.775	± .002	.775	✓		"	"
1.000	± .005	.997	✓		"	"
1.225	± .002	1.225	✓		"	"
1.310	± .002	1.310	✓		"	"
1.355	± .005	1.355	✓		"	"
1.384	± .005	1.384	✓		"	"
1.805	± .002	1.806	✓		"	"
Ø .432	± .001	.432	✓		MIC	PHD-02
Ø .544	± .001	.544	✓		"	"
.750 HEX	± .005	.749	✓		VERN	PHD-12
R. 405	± .005	.405	✓		"	"
1.156	± .005	1.154	✓		"	"
Ø .328	± .005 ± .006	.330	✓		"	"
Ø .313	± .006	.313	✓		"	"
.050 X 45°	± .005	.045	✓		"	"

Measured by: DAS 40	Audited by: DAS 37	Preliminary Approval:
Date: 15/04/06	Date: 15.04.06	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

Linda Lacelle

From: Jean-Luc Menard
Sent: April-06-15 10:35 AM
To: Linda Lacelle
Subject: Fwd: 650.6316

Sent from my iPhone

Begin forwarded message:

From: Dave Barker <DBarker@dartaero.com>
Date: April 2, 2015 at 1:41:29 PM EDT
To: Jean-Luc Menard <jmenard@dartaero.com>, Nigel Forbes <nforbes@dartaero.com>, Alvin Butler <abutler@dartaero.com>
Subject: RE: 650.6316

Correct. Same as before.

Thanks,

Dave

From: Jean-Luc Menard
Sent: Thursday, April 02, 2015 10:30 AM
To: Dave Barker; Nigel Forbes; Alvin Butler
Subject: RE: 650.6316

Let me shuffle some stuff around, I will get them done.
Same as before? No passivation and Cond H900 material.

From: Dave Barker
Sent: April-02-15 1:24 PM
To: Jean-Luc Menard; Nigel Forbes; Alvin Butler
Subject: RE: 650.6316

We need 3 to 5 ASAP. Any change we could get 1 done sooner than Wednesday?

Thanks,

Dave

From: Jean-Luc Menard
Sent: Thursday, April 02, 2015 10:23 AM
To: Dave Barker; Nigel Forbes; Alvin Butler
Subject: RE: 650.6316

Hi Dave,
How many would you need?
We could ship out next Wednesday to you.
I have lots of people off this weekend due to being Easter.
Let me know,
JL

From: Dave Barker
Sent: April-02-15 1:15 PM
To: Nigel Forbes; Jean-Luc Menard; Alvin Butler
Subject: FW: 650.6316

Nigel and JL – need your help putting out another fire if you have some machine availability. The fitting you made for us last week has changed design again slightly. The first 2 images show the new design and the last image shows the dimensions that changed. We need some of these ASAP. What is realistic delivery date for you to be able to make some of these?

Thanks for your help.

Thanks,

Dave

From: Tyler Cross
Sent: Thursday, April 02, 2015 10:09 AM
To: Alvin Butler

Cc: Dave Barker

Subject: 650.6316

Alvin,

In order to make the valves for testing in 2 weeks, We will need more of the 650.6316.

Here are screen shots of the drawing so we can get an idea of the changes being made.

I'll have the ECN done by the end of the day today.

Tyler